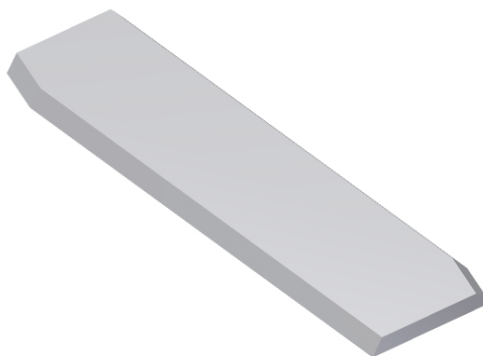














2-sided WoodInserts with chamfer

A09-900

The cycle time for a 2-sided reversible knife includes handling - loading and rotating - as well as the grinding of the 2 sides. To keep the time low grinding and handling operations have been optimized to a minimum of movements and the usage of one single wheel, which allows to grind the 45° clearance of the main cutting edge and the chamfer in one pass. After having rotated the reversible knife, a location probing is necessary



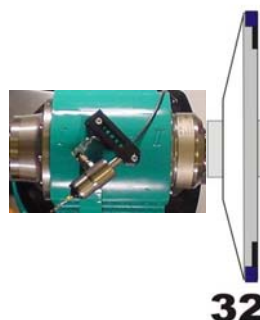
1. Cycletime for Production

Tool specifications from rectangular blank 50x14 Material CARBIDE							
Operations							
	Chamfer	1st side	Rotate tool	Probing	Chamfer	2nd side	Loading
Feed [mm/Min]	200	500	2000	200	200	500	2000
Power [kW]	1	1		1	1	1	
Cutting feed [m/s]	34	34		34	34	34	
Used wheels							
	32	32		32	32	32	
Grinding time [s]	6	14	9	16	6	14	9
Total cycle time	1 Min 13						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

32 Ø250 12C9 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM, STL 650
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 4.3

responsible engineer: KOC, 12.8.08

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